

Date: Wednesday, 7/4/2007 10:17:31 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPAD		
Job Number	: 33284		Part Number	: D35371		
Estimate Number	: 12712		Drawing Number	: D3537 REV C		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 7/4/2007	S.O. No. : N/A	Drawing Revision	: C		
Prsht Rev.	: NC	Type : SMALL /MED FAB	Material	: N/A		
First Issue	: N/A		Due Date	: 7/22/2007		
Previous Run	: 33227		Qty:	40	Um:	Each
Written By	:		Comment	: Est Rev.A New Issue 07-02-14 JLM		
Checked & Approved By	:		07.07.04			
Comment	:					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet
Comment: Qty.: 0.0788 sf(s)/Unit Total : 3.1500 sf(s) M304S16GA .063" 304 SS SHEET Batch: M 7106 1B 07-07-06		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3537 Dwg Rev: C Prog Rev: C		
	2-Deburr if necessary	1B 07-07-06
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE 1B 07-07-06		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK SJ 07/07/10 X 40		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE 1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1		
		SB 07/07/10 40

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3537-1 PAR #: _____ Fault Category: _____ NCR: Yes ○ No DQA: Date: 07-07-20
 QA: N/C Closed: _____ Date: _____

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/10	2.0	The .220 X 0.380 holes are under size by 0.015". R.C. Jet offset	081042	open holes manually using A fine tip & die grinder. to bring holes within tolerance.	07/07/10 FT	EN 07/07/10	081042	081042

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 33284

Part Number: D35371

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 LARGE TAB 1



LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch
A/R 2059B Hardcoat 1104463

88 07/07/15
88 07/07/15

(28)

1-Weld as per Dwg D3537 using Jig DT 8210
2-Remove any weld that penetrated through Wearpadif necessary

(29)

7.0 QC9



VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

1102/07/16 (28)

8.0 QC5



INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1102/07/16 (28)

9.0 POWDER COATING



POWDER COATING



m 104846

(28)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

BK/m/07-07-18

10.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



Fel

07/07/18 (28)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0 PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-18

m-f 07/07/19

12.0 QC21



FINAL INSPECTION/W/O RELEASE



07.07.19 (28)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 07.07.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

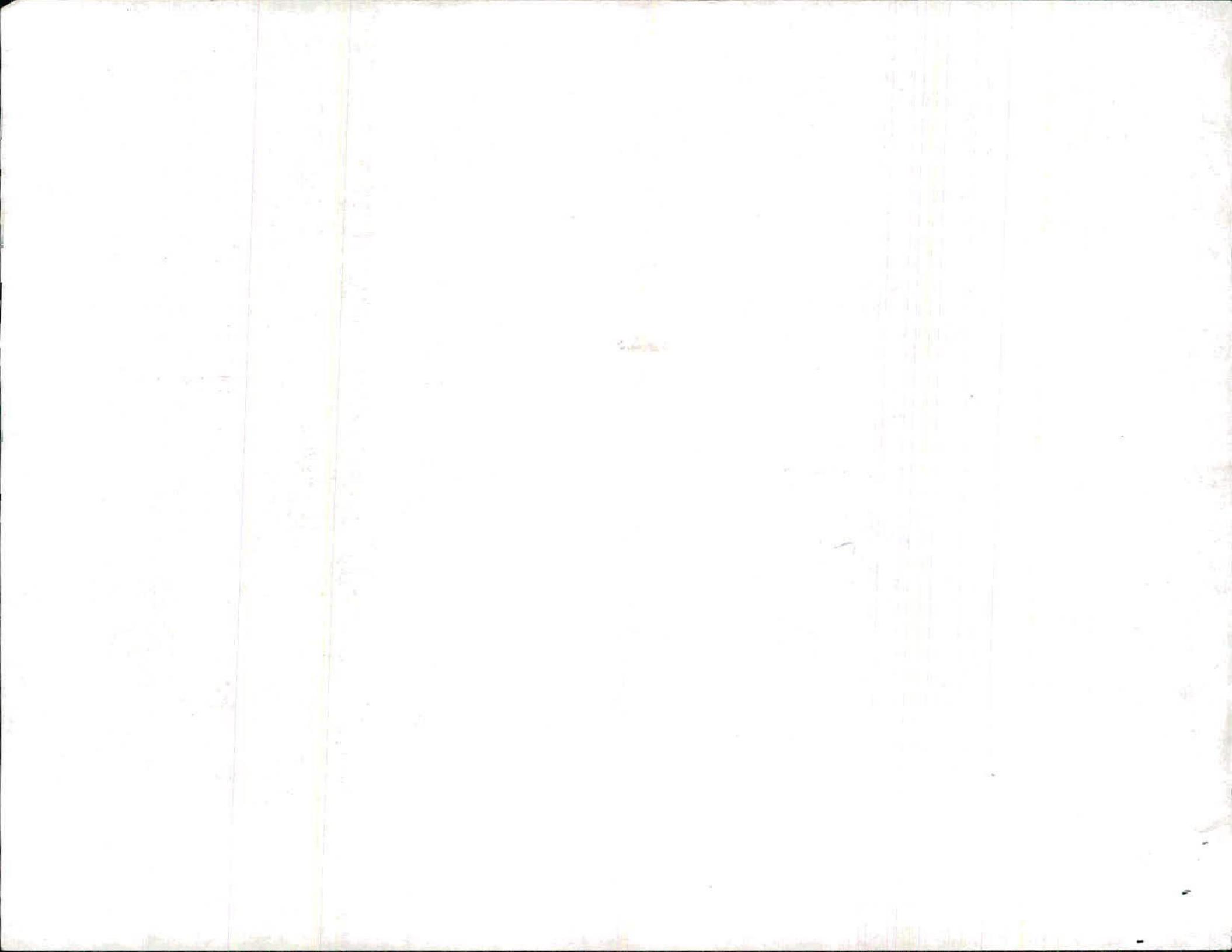
DART AEROSPACE LTD	Work Order:	33284
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

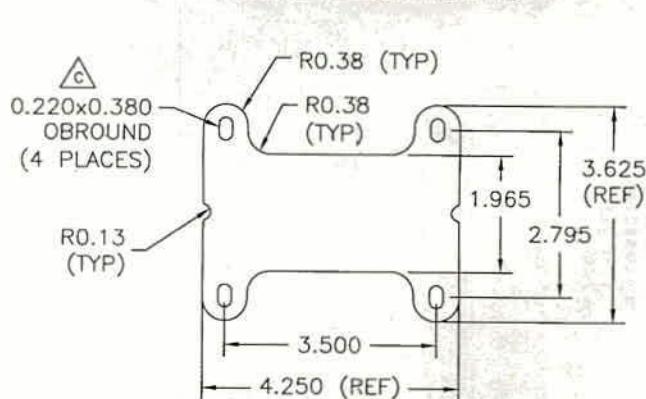
X First Article Prototype

Measured by: <u>HB</u>	Audited by: <u>SD</u>	Prototype Approval:	N/A
Date: <u>07-07-06</u>	Date: <u>07-07-06</u>	Date:	N/A

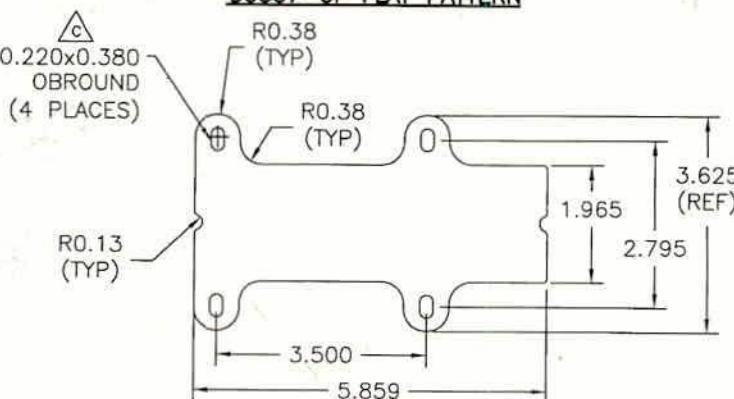
Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	<i>[Signature]</i> <i>[Signature]</i>



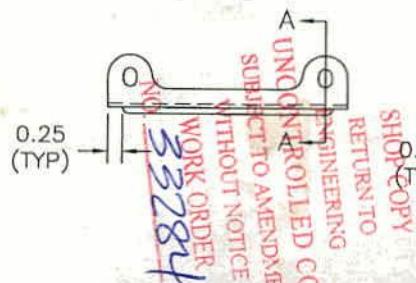
D3537-1F FLAT PATTERN



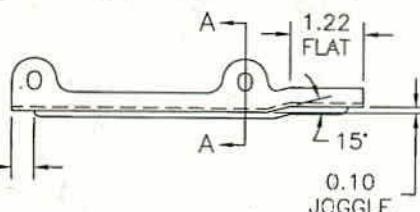
D3537-3F FLAT PATTERN



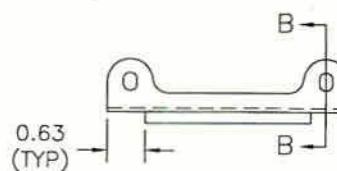
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



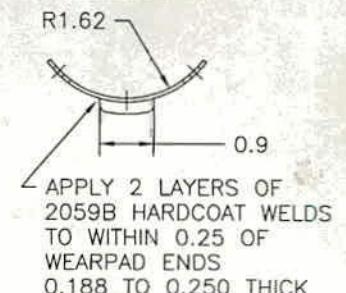
D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



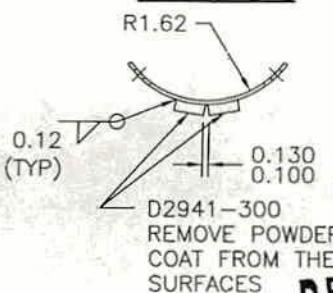
D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SECTION A-A

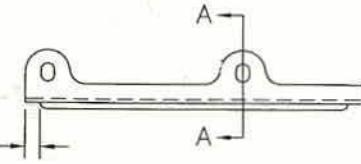


SECTION B-B



RELEASED
07.05.08 AF
PER ECN
952

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	#	APPROVED # DRAWING NO. B3537 REV. C
DATE	07.04.13	TITLE WEARPAD SHEET 1 OF 1 SCALE 1:2

